



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5012844

12

D4956-11
Job Sheet 168725



Part No: D4956-11

Job Qty: 8 ea

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Created By: Linda Lacelle

Description:

Due Date: 11/24/17

Type: AOG

Note: DWG REV A SHEETS 1,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Waterjet		SE
100	Waterjet	8 pcs	11/23/17	11/23/17	0.00	1.40	Waterjet1		SE DAS
120	QC	8 pcs	11/23/17	11/23/17	0.00	0.00	QC8		38
130	Brake NC	8 pcs	11/23/17	11/23/17	0.12	0.39	Brake NC 1		DAS 9-89
140	QC	8 pcs	11/23/17	11/23/17	0.00	0.00	QC5		38
150	HandFinish	8 pcs	11/24/17	11/24/17	0.00	0.23	HandFinish4		AS NOV 28 2017
160	QC	8 pcs	11/24/17	11/24/17	0.00	0.00	QC3		17/11/28 15
170	Packaging	8 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		9-89
180	QC21-SA	8 Ea	11/24/17	11/24/17	0.00	0.00	QC21		21 NOV 28 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	5	116	0	0

Rockguard 138637

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875		
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	5.000Inches ± 0.030	5.030 4.970		
7	Wearshoe	7.650Inches ± 0.010	7.660 7.640		
8	Wearshoe	11.150Inches ± 0.010	11.160 11.140		
9	Wearshoe	15.400Inches ± 0.010	15.410 15.390		

DART
AEROSPACE
S013193



Wearplate Fwd

PART NO: D4956 – 11
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/23/17 Job No: 168725
--

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero-space.com

10	Wearshoe	19.000Inches ± 0.030	19.030 18.970
11	Wearshoe	19.650Inches ± 0.010	19.660 19.640
12	Wearshoe	23.150Inches ± 0.010	23.160 23.140
13	Wearshoe	25.150Inches ± 0.010	25.160 25.140
14	Wearshoe	28.650Inches ± 0.010	28.660 28.640
15	Wearshoe	29.030Inches ± 0.030	29.060 29.000

Plex 11/21/17 2:56 PM dart.lacelle.linda

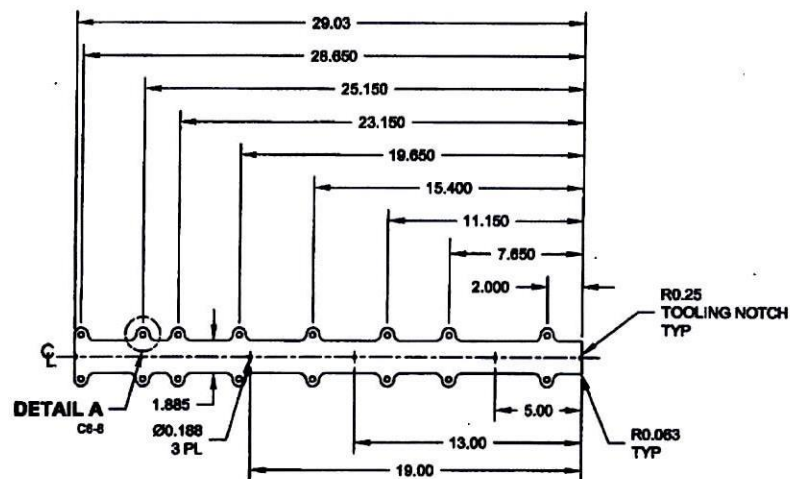
DART AEROSPACE LTD		Work Order: 168725
Description: wearplate FWD		Part Number: D4956-11
Inspection Dwg: A	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

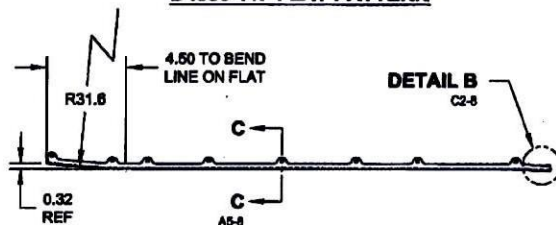
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,188	+0,005-0,001	0,188	1		VD-02	
0,300	+/- 0,010	0,301	1		Tape	
0,300	+/- 0,010	0,302	1			
1,885	+/- 0,010	1,886	1			
2,000	+/- 0,010	2,000	1			
5,000	+/- 0,010	5,000	1			
7,650	+/- 0,010	7,651	1			
11,150	+/- 0,010	11,151	1			
15,400	+/- 0,010	15,401	1			
19,000	+/- 0,030	19,000	1			
19,650	+/- 0,010	19,651	1			
23,150	+/- 0,010	23,151	1			
25,150	+/- 0,010	25,151	1			
28,650	+0,010	28,651	1			
29,030	+/- 0,030	29,035	1			

Measured by: SC	Audited by: DAS 38 9-88	Preliminary Approval:
Date: 17/11/23	Date: NOV 24 2017	Date:

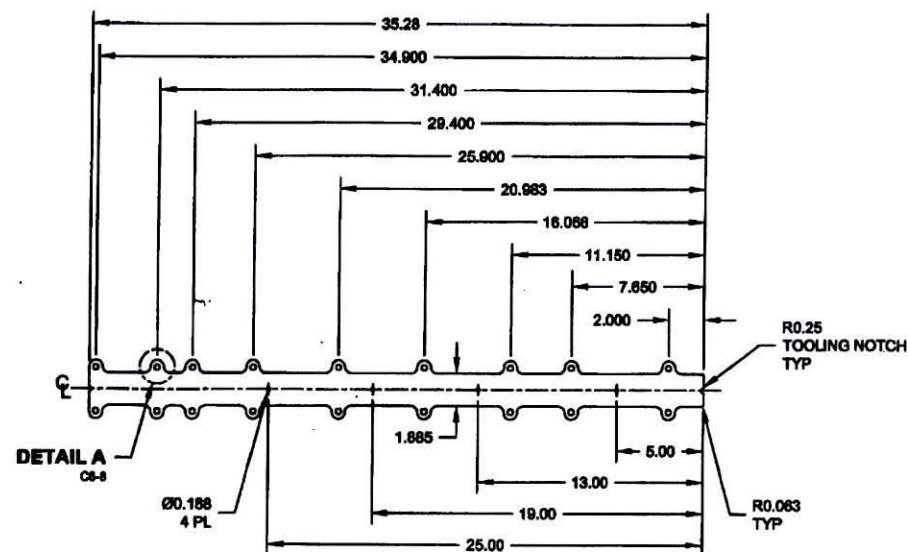
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



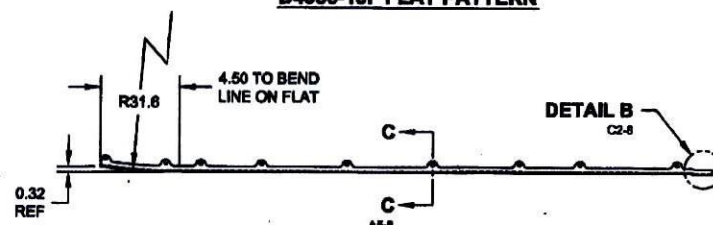
D4956-11F FLAT PATTERN



D4956-11 WEARSHOE
(MAKE FROM D4956-11F)



D4956-13F FLAT PATTERN



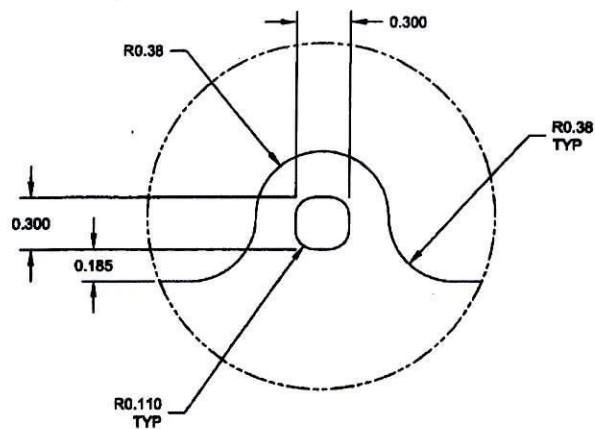
D4956-13 WEARSHOE
(MAKE FROM D4956-13F)

NOTES

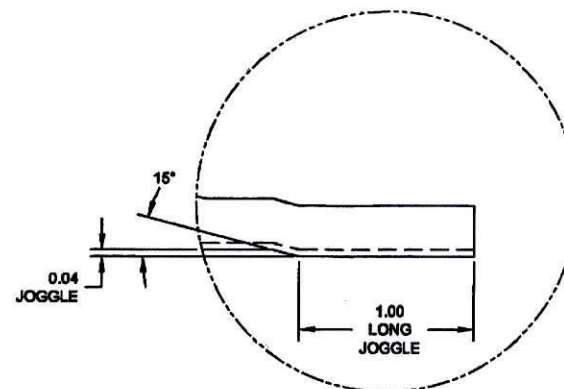
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-11 = 0.58 lbs; D4956-13 = 0.82 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2014-04-17

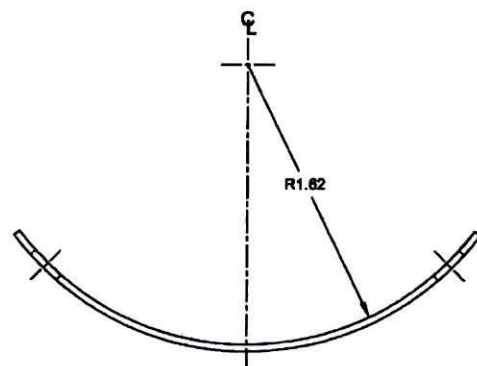
A NEW ISSUE		DESCRIPTION		MB	13.09.26
REV.				BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D4956		SHEET 1 OF 8	
APPROVED		TITLE		SCALE	
DE APPR.		WEARSHOE		NTS	
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C2-4
C8-6 C2-6
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B5-4
B7-5 B3-5
B7-6 B3-6
B7-7 B3-7

RELEASED
2014-04-17
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	BS	D4956	SHEET 8 OF 8
APPROVED	19	TITLE	SCALE
DE APPR.	19	WEARSHOE	NTS
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPIRATION DATE 17-11-2013. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	